

Date: Tuesday, 12/5/2006 8:01:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 STEP ASSEMBLY, SHORT HIGH SKID
Job Number : 29746	
Estimate Number : 10460	
P.O. Number : N/A	Part Number : D350591113
This Issue : 12/5/2006 S.O. No. : N/A	Drawing Number : D2310 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : D
Previous Run : 28509	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 1/10/2007
Checked & Approved By : <i>[Signature]</i> 06.12.05	Qty: 10 Um: Each
Comment : Est Rev: H 04.11.09 Reformat KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-591-113 CHG003

KS 06.12.11

2.0	D2244116	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2244	Step Extrusion	<i>B23404</i>

PE. 06.12.7 10

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310

2-Drill extrusion as per Dwg D2310 using drill Jig DT8230 *PD 06.12.21 (10)*3-Deburr *PD 07.01.06 (10)*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP*207.01.06 10*

5.0	D267334	End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29746

Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2673-34

End Cap

B25396

PD 07-01-08 (10)

6.0

D2275

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D2275

Bushing

B17557-56
B27755-54

PD 07-01-08 (10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd end cap and bushing as per Dwg D2310

A/R AL ROD Batch: M102225 -> bushing
M100237 -> caps

2-Grind end cap and bottom bushing welds flush

3-Machine top weld on bushing flush

PD 07-01-08 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07/01/08 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07/01/08 (10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PD 07-01-08 (10)

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part number

Description

Batch

16 MS20600AD4W3 Rivet

M101519

PD 07-01-09 (10)

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Part Number: D350591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part number Description

Batch

1 D2582 Step Leg Assembly

628791

PD 07-01-09 (10)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: M100237

4-Grind end cap welds flush

PD 07-01-09 (10)

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M07/01/09 (10)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M07/01/09 (10)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Y/L

07/01/09 x10

17.0

POWDER COATING

POWDER COATING



M102391



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M07/01/10

07/01/10

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2310 and QSI 005 4.4

Batch: m 103004

F.L.P.M.

02/01/10

(10)

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



m 07/01/11



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION AND WING WALK

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

K591113

Short Step Instln Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick Packing Kit:

Qty Part number

Description Batch

1 K591-113

Hardware Kit

B29747

P 7/10/11

(10)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 7/10/11

(10)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-113

Location: Dev H

Dev H

P 7/10/11

(10)

P 04/01/11

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/11

Job Completion



07.01.11

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16 *

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29746

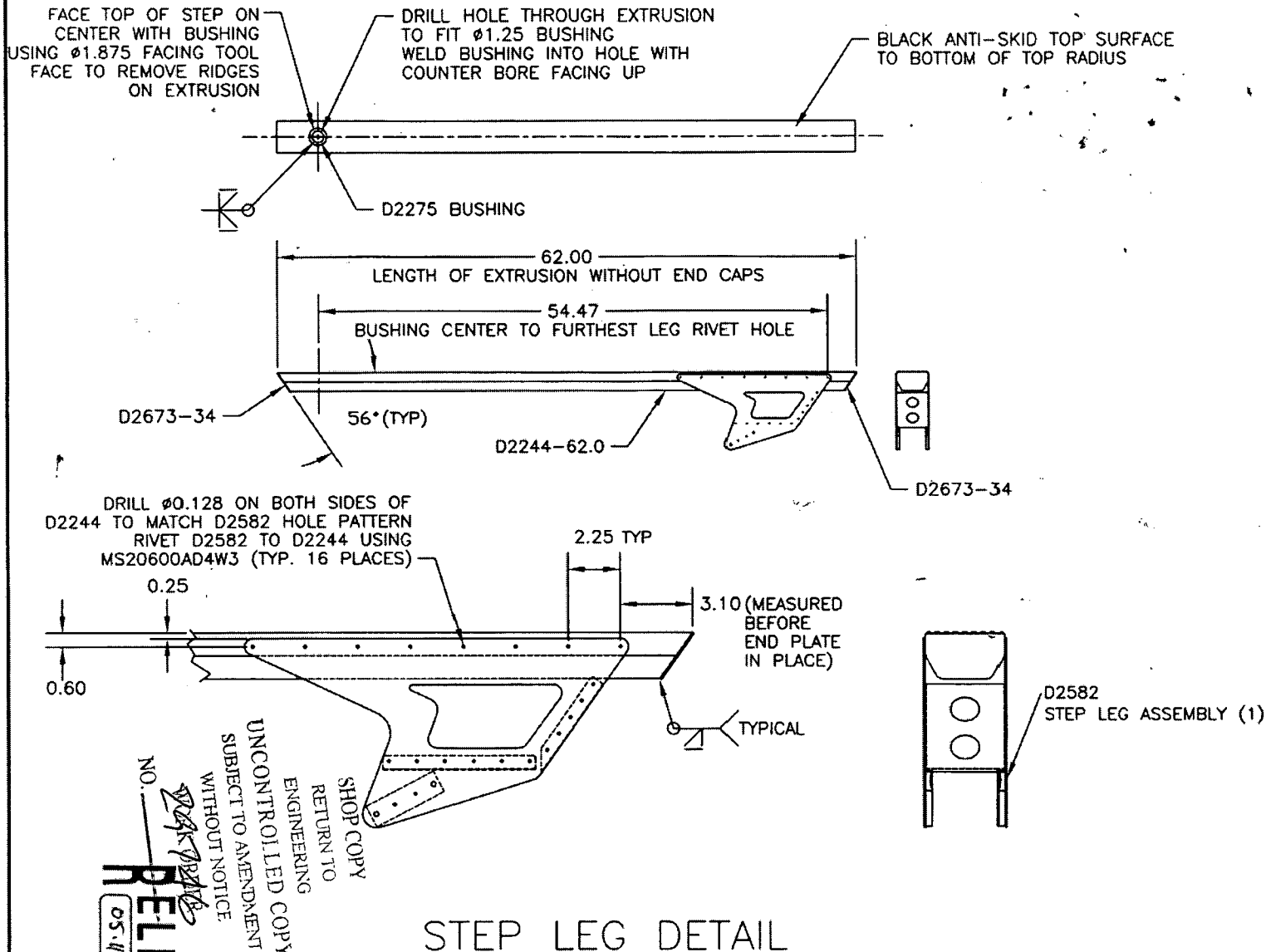
RELEASED
05.11.28 [Signature]

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2310	SHEET 2 OF 2
DATE	TITLE	SCALE	
05.11.14	HIGH SHORT STEP ASSEMBLY	NTS	



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14